

Date: Tuesday, 3/11/2008 7:57:42 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 37753		
Estimate Number	: 10346		
P.O. Number	:	Part Number	: D2596
This Issue	: 3/11/2008 S.O. No. :	Drawing Number	: D2596 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 36872	Material	:
Written By	:	Due Date	: 3/31/2008 Qty: 16 Um: Each
Checked & Approved By	: <u>JA08 03 11</u>		
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n - "I" Beam Web 4"
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Comment: Qty: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	B- 33940 - AWM 8-3-13

16 PCS

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Cut D2500-3-100 to length: 99.5"

2- Use Jig DT8093 to drill pilot holes #30

3- Open to 0.630" diameter as per Dwg D2596

4- Deburr

AWM 8-3-14 - 16 PCS

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

AWM 8-3-14

PTU

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 08/03/17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2596 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: D Date: 08/03/19  
 QA: N/C Closed: K Date: 08/03/19

NCR: <u>37753</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-03-17	3.0	1 web was left in the acid tank for 72 hours.  Human error.		Scrap; replace  Qty 1 33940 B. <u>32753</u>	4-3-17 A.W.M.	QC 08-03-17		

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 37753

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G. AWM S-3-17

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(16)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/03/19

Job Completion



2008/3/17

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

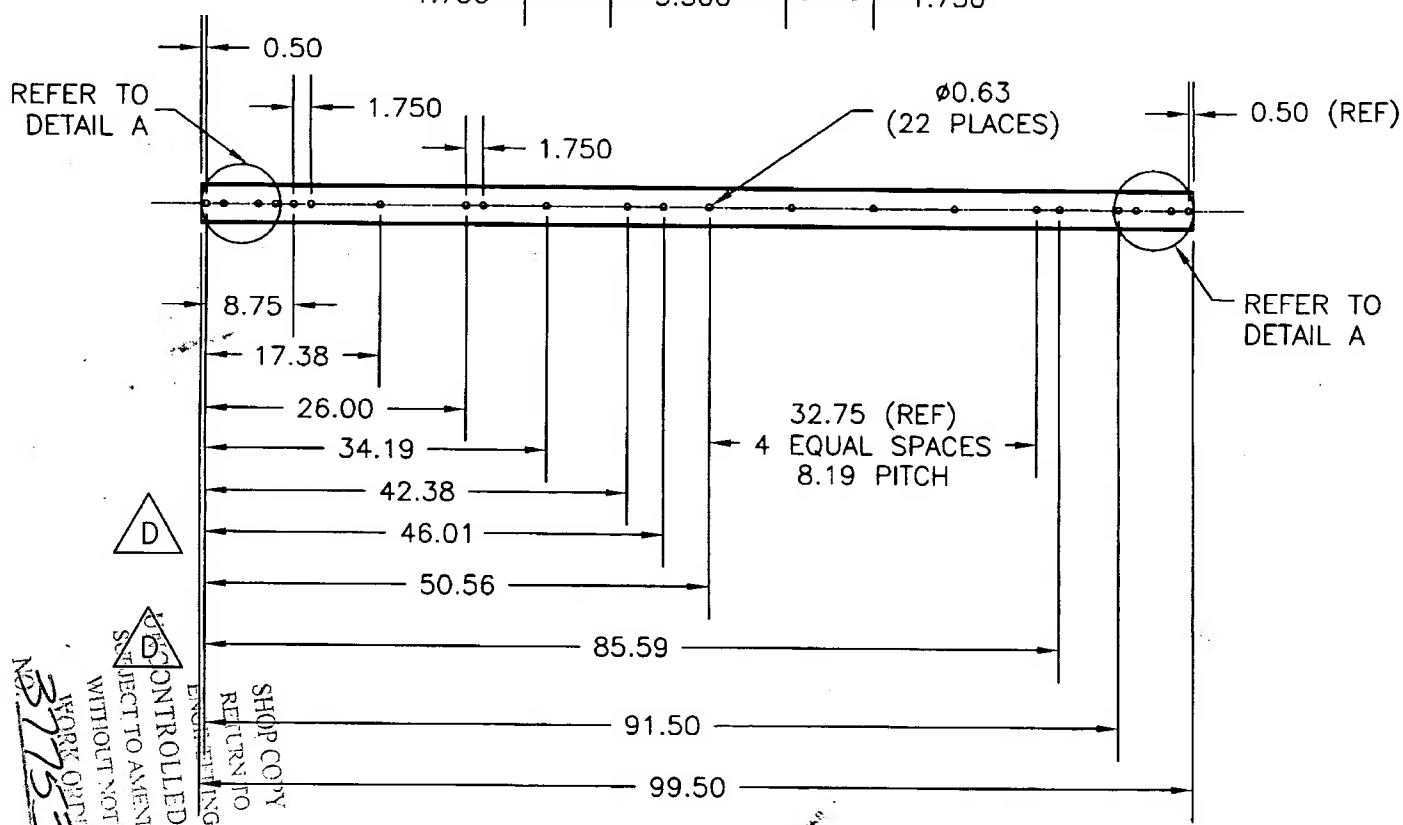
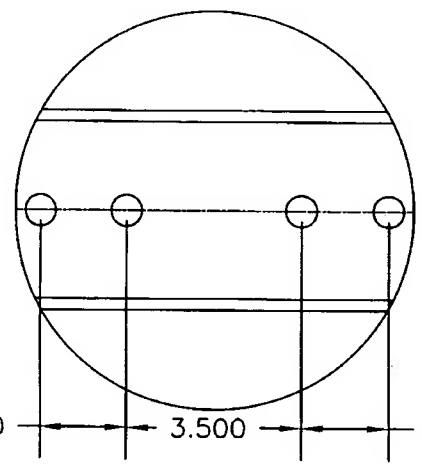
NOTE: Date & initial all entries



RELEASED  
07 06 28

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
04	04	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
<i>[Signature]</i>	<i>[Signature]</i>	D2596	
DATE	TITLE	SCALE	
07.04.17	205 WEB	1:20	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

DETAIL A  
SCALE 1:4



D

CONTROLLED COPY

WORK ORDER  
NO. 37753

D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020